

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010300**Date Inspected:** 02-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yu Dong Ping, Chen Ying Xin.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay 11, South tower, Strut Plate.

SAW welding of weld joint SD1-STSA3-109M-1-6B; located on Bay 11, South tower. Welders are identified as 040772; ZPMC Quality Control Inspector (QC) is identified as Yu Dong Ping. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-4221-B-U3C-S-1.

Bay 11, West Tower, Interior Splice.

During random in process inspection this Caltrans Quality Assurance (QA) Inspector observed ZPMC performing weld repair of Surface Overlay on Interior Splice Plate WSD1-SA236 by Shielded Metal Arc Welding (SMAW) process. Upon asking for Weld Repair Report (WRR) ZPMC QC (CWI) "Yu Dong Ping" provided Weld Repair Report (WRR # T-WR2606) for 6mm of overlay repair by Flux Core Arc Welding (FCAW) process. This Caltrans Quality Assurance (QA) Inspector have written Incident Report on the same date.

Bay 11, West Tower, Lift 4, Skin B, B/C Corner, Near 131M, Temporary Attachment Area.

During random visual inspection at Bay 11, West Tower, Lift 4, Skin B (Temporary Attachment Area near Corner Seam B/C) this Caltrans Quality Assurance (QA) Inspector observed "Crack Like" indications at the removed Temporary attachment Weld area. The indications were shown to ZPMC and ABF QC Inspectors. No

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Incident Report has been written on this issue. The attached photographs provide additional detail.

Bay11, East Tower, Lift 4, Fit lugs.

FCAW welding of weld joint ESTL4-2K/L-94, 99, 100; located on Bay11, East Tower, Lift 4. Welders are identified as 048810; ZPMC Quality Control Inspector (QC) is identified as Zhan Bo. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-4333-TC-P4-F.

Bay10, North Tower, Lift 4, A/E Corner Seam.

FCAW welding of weld joint NSTL4-3B/L-3B; located on Bay10, North Tower, Lift 4. Welders are identified as 053869; ZPMC Quality Control Inspector (QC) is identified as Liu Zhong An. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U4B-F.

Bay 11, East tower, Corner Angle Splice.

SMAW welding of weld joint ED1-SA3-18-89M-5-1A; located on Bay 11, East tower. Welders are identified as 053049; ZPMC Quality Control Inspector (QC) is identified as Chen Ying Xin. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-3211-TC-U5B-1.

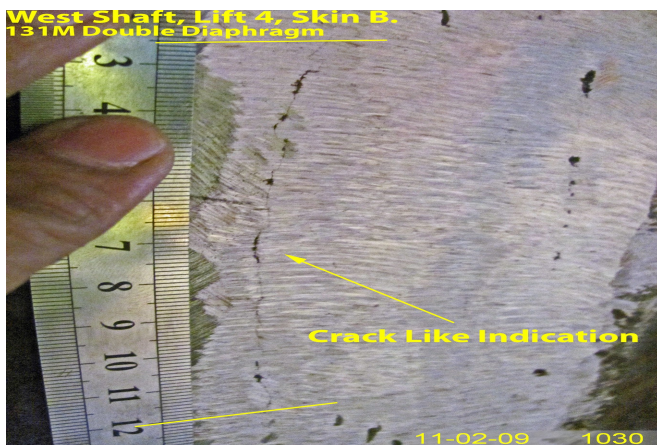
This QA Inspector carried out NDE on following

Bay 11, West Tower, Tower Strut Plate.

This QA inspector performs Random Ultrasonic Testing (UT) of approximately 10% area previously tested and accepted by ZPMC Quality Control personnel, FOR GREEN TAG. This QA Inspector generated an UT report(TL-6027) for this date. The members are identified as

- 1) WD1-STSA3-2-109M-1-1A, 2B, 4A, 6B.
- 2) WD1-STSA3-2-109M-2-1A, 2B, 4A, 6B.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 13482570045, who represents the Office of Structural Materials for your project.

Inspected By:	Juvekar,Amit	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
